



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9309	REV. A SHEET 1 OF 2
DATE 05.09.26		TITLE SEAL KIT	SCALE NTS
A	05.09.26	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-694 REV. B

REF. CANADIAN STC: SH05-10

REF. FAA STC: SR02086NY

TO CLOSE THE GAP BETWEEN AIRCRAFT AND D412-694-01/-02 DOOR ASSEMBLY IT IS ACCEPTABLE TO INSTALL D3116-9-0520 SEAL AS SHOWN BELOW IN LIEU OF INSTALLING THE D3116-3-0520 SEAL PER IIN-D412-694.

ADD THE FOLLOWING PARTS TO THE LIST OF IIN-D412-694. CUSTOMERS WITH EARLY MODEL D412-694-011 KITS CAN PROCURE THE DSI 9309-011 KIT FROM DART TO DO THIS MODIFICATION.

-011	Part Number	Description
X	D412-694-011	SPACEDOOR MODIFICATION
X	DSI 9309-011	SEAL KIT
2	D3116-9-0520	SEAL
2	D3144-15	DOUBLER
48	BSP45	RIVET

PROCEDURE:

- 1) LOCATE D3116-9-0520 SEAL ON D412-694-01/-02 DOOR ASSEMBLY SO THAT IT WILL REST AGAINST EXISTING AIRCRAFT SEAL WHEN DOOR IS CLOSED. ENSURE PROPER ORIENTATION OF SEAL.
- 2) TRIM D3144-15 DOUBLER AND D3116-9-0520 SEAL AS NECESSARY TO CLEAR BRACKETS ON AFT EDGE OF DOOR. ENSURE MINIMUM EDGE DISTANCE OF 0.40" (10 mm) FROM THE RIVET HOLES.
- 3) TRANSFER DRILL Ø0.129" (#30) FROM DOUBLER, THROUGH SEAL AND INTO THE DOOR. DEBURR AND INSTALL DOUBLER & SEAL USING BSP45 RIVETS. SEAL RIVETS WITH RTV-732 SEALANT.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED



BY:
D. SHEPHERD (DE # 02)

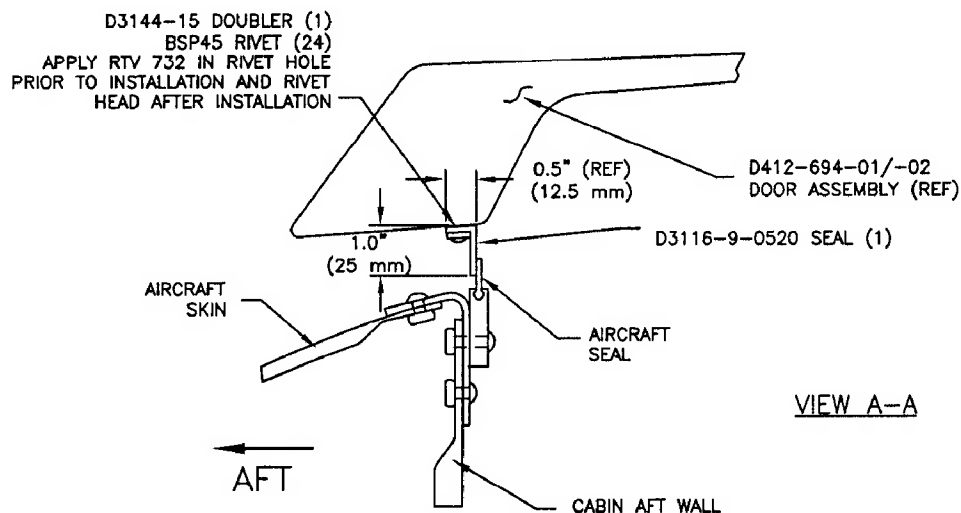
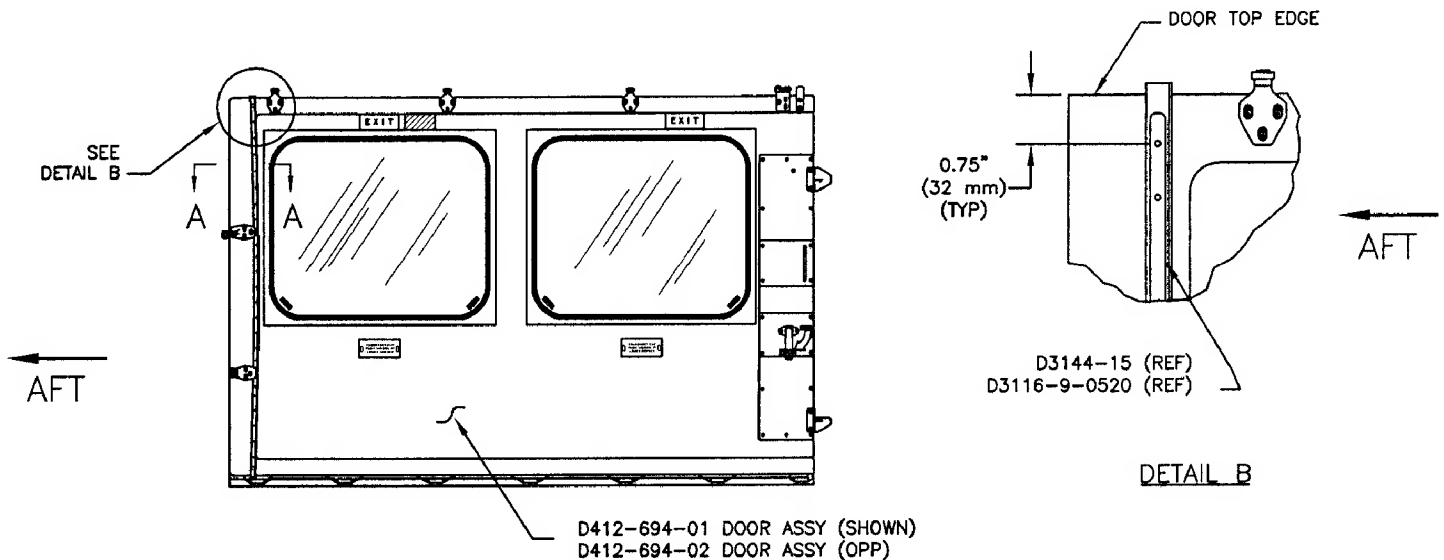
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9309	REV. A SHEET 2 OF 2
DATE 05.09.26	TITLE SEAL KIT		SCALE NTS



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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